

Work Order ID 82826

82826

Page 1

Tuesday, April 10, 2012 12:51:32 PM

Item ID: D4571-3 Accept ***N9000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cover
 Start Date: 4/10/2012 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 4/10/2012 Req'd Qty: 5.00 ***5*** Customer:
 Reference: REWORK

Approvals: Process Plan: *MF* Date: *12-04-10* Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4571	B

170 0.00
170
 QC
 Quality Control

WOK 12-4-10

Memo
 PULL FROM STOCK D4571-3 X 5 B 80805
 UPON INSPECTION, IT WAS FOUND THAT SOME HOLES HAD TO BE REDRILLED AND RETAPPED
E 12/4/10

8/11

180 0.00
180
 Mill Conv
 Conventional Milling Machine

12-4-11

Memo
 RETAP AND REDRILL PER DRAWING

2

190 0.00
190
 QC
 Quality Control

QC5- Inspect part completeness to step on W/O

5/26/11

Memo

(8)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Tuesday, April 10, 2012 12:51:32 PM

Page 2

Accept

Setup Start *NS1*

Stop *NS2*

Start Date: 4/10/2012 **Start Qty:** 5.00 ***5***

Required Date: 4/10/2012 **Req'd Qty:** 5.00 ***5***

Cust Item ID:

Reference: REWORK

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

Fire Red(Ref:4.3.5.10) per QSI005 4.3

0.00

Memo

0.00

Powdercoat

Powder Coating

~~TOUCH UP WITH ALODINE AND TOUCH UP WITH POWDER COAT RED
IF NECESSARY~~

0.00

QC3- Inspect Part Finish

0.00

Memo

QC

Quality Control

Identify as per dwg & Stock Location: 487 0.00

0.00

Memo

0.00

Packaging

Packaging

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82826***82826***

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Tuesday, April 10, 2012 12:51:32 PM

Item ID: D4571-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Cover

Stop ***NS2***

Start Date: 4/10/2012 Start Qty: 5.00

5

Cust Item ID:

Required Date: 4/10/2012 Req'd Qty: 5.00

5

Customer:

Reference: REWORK

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

12/4/18 [Signature]
R1204-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Tuesday, April 10, 2012 12:51:32 PM

Page 1

Work Order ID: 82826

Parent Item: D4571-3

Parent Item Name: Cover

Start Date: 4/10/2012

Required Date: 4/10/2012

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A NEW ISSUE 11-12-21 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4571-3 Cover		Manufactured	No				Each	0.0000		5			

5x D4571-3 B 80805

MF 12-04-20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

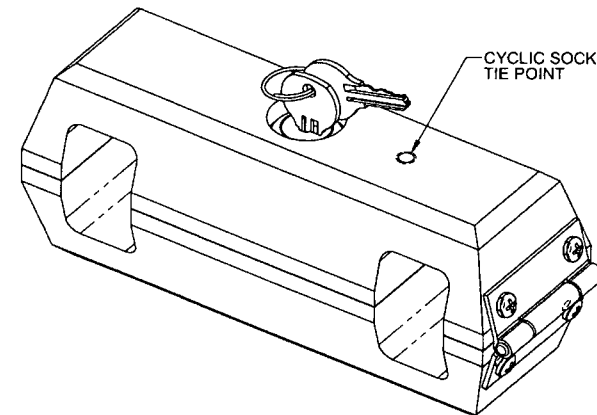
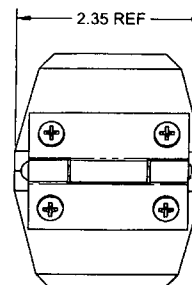
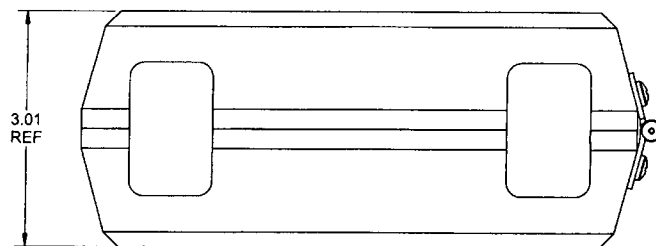
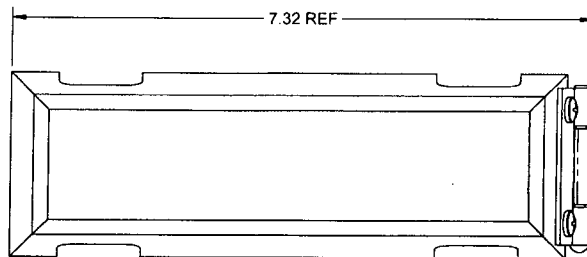
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	QTY -051	P/N	DESCRIPTION
	X		D4571-041	TAIL ROTOR DISABLING KIT
	1	X	D4571-051	PEDAL LOCK
	1		D3384-047	CYCLIC SOCK
	1		MS 16995-47	SCREW, SKT-HD
	2		AN960-416	WASHER, FLAT
1		1	D3373-5	CAM LOCK ASSEMBLY
2		1	D3385-3	HINGE
3		1	D4571-1	BASE
4		1	D4571-3	COVER
5		4	MS51957-41	PH-HD SCREW, #8
6		2	97395A461	DOWEL PIN (MCMaster CARR)



82806

RELEASED
2012-01-30

D4571-051 PEDAL LOCK

B	ADDED CYCLIC SOCK AND RELATED HARDWARE TO BOM ADDED DIM 0.560, DELETED DIM 0.188 SHT 3 ADDED DIM 1.200, DELETED DIM 0.300 SHT 4	RP	12.01.23
A	NEW ISSUE	RP	12.01.06
REV.	DESCRIPTION	BY	DATE
DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	MP	DRAWING NO.	REV. B
MFG. APPR.	MP	D4571	SHEET 1 OF 4
APPROVED	MP	TITLE	SCALE
DE APPR.	N/A	PEDAL LOCK	NTS
DATE	12.01.23	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

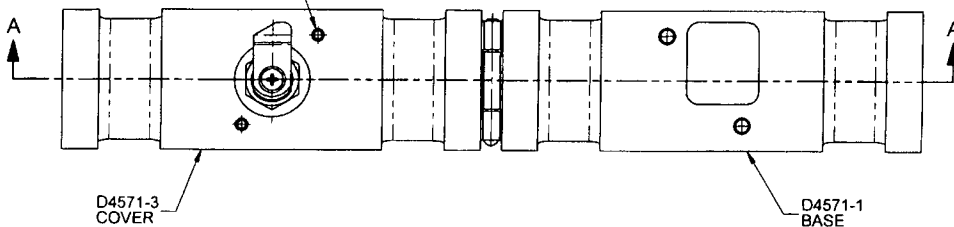
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

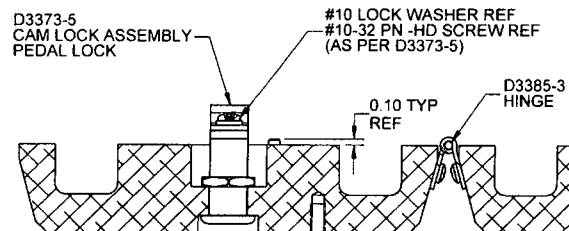
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

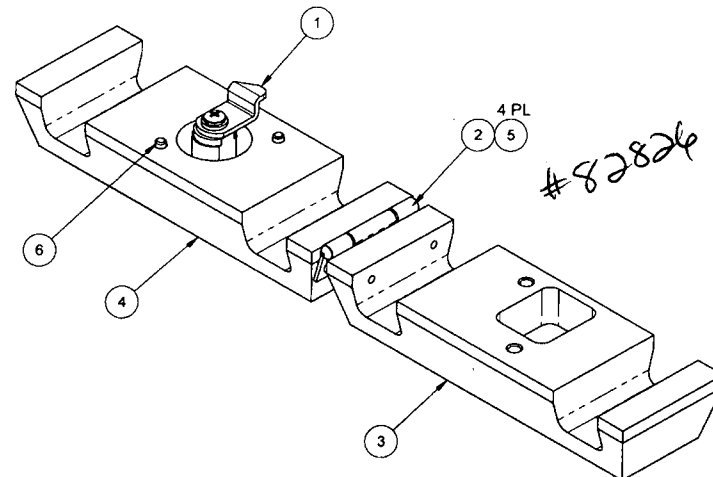
97395A461
DOWEL PIN (MCMaster CARR)



D4571-051 PEDAL LOCK ASSEMBLY



SECTION A-A



RELEASED
2012-01-30

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.75 lbs

DESIGN	RP	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MP	DRAWING NO. D4571	REV. B
MFG. APPR.	MP	SHEET 2 OF 4	
APPROVED	MP	TITLE	SCALE
DE APPR.	N/A	PEDAL LOCK	NTS
DATE	12.01.23	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

Dart Aerospace Ltd

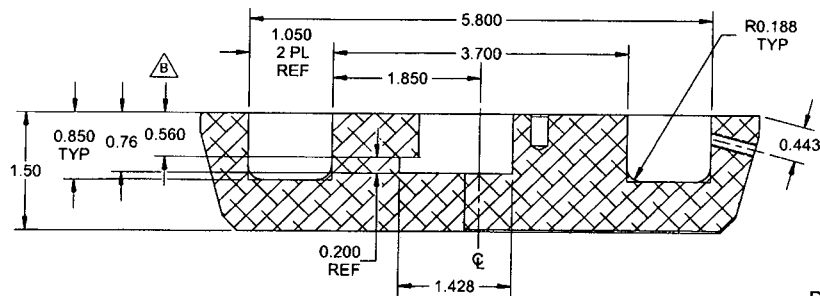
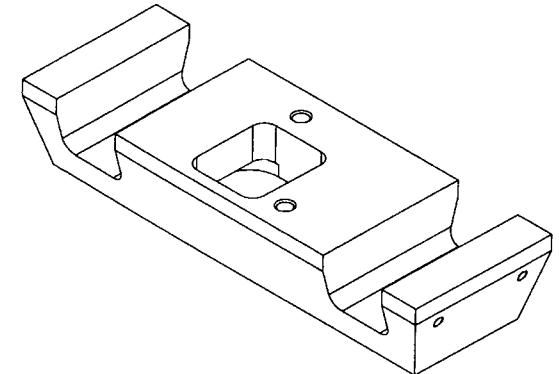
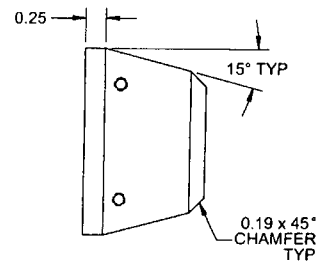
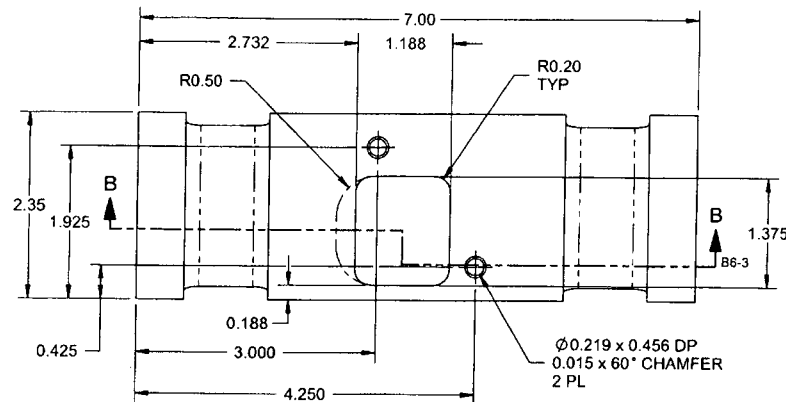
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

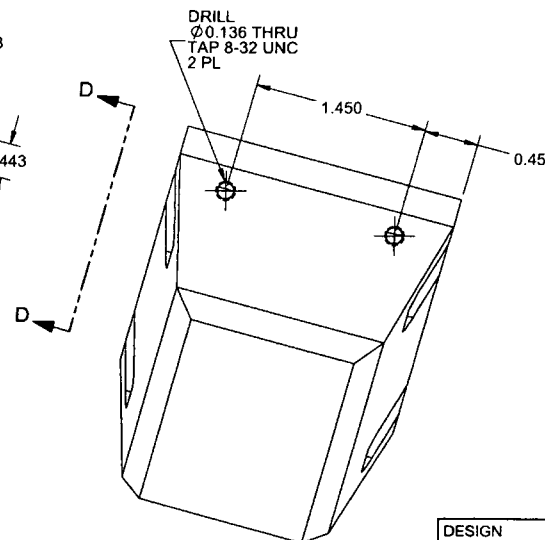
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



SECTION B-B C6-3



VIEW D-D

NOTES:

- 1) MATERIAL: 6061-T6/T651 PER QQ-A-200/8 OR QQ-A-225/8 OR ASTM B211 OR ASTM B221 REF. DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) MASK INSIDE HOLES PRIOR TO FINISH

D4571-1 BASE

RELEASED
2012-01-30

DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	MP	DRAWING NO. D4571	REV. B
MFG. APPR.	<i>[Signature]</i>	TITLE PEDAL LOCK	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	SCALE NTS	
DE APPR.	N/A	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	12.01.23		

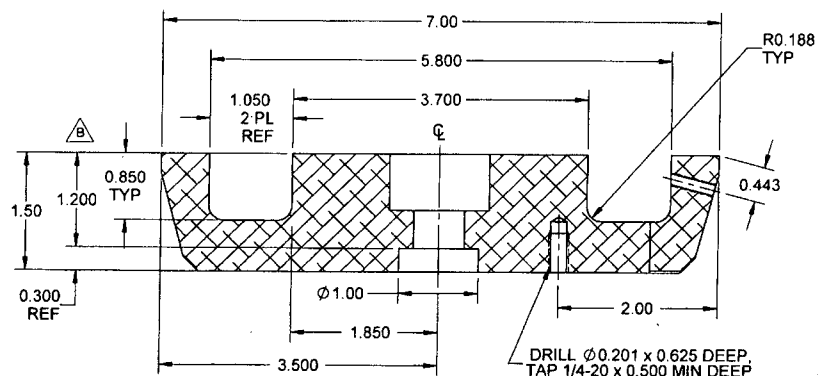
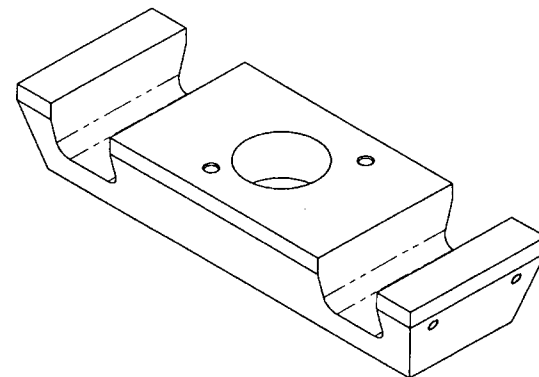
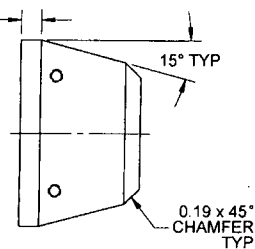
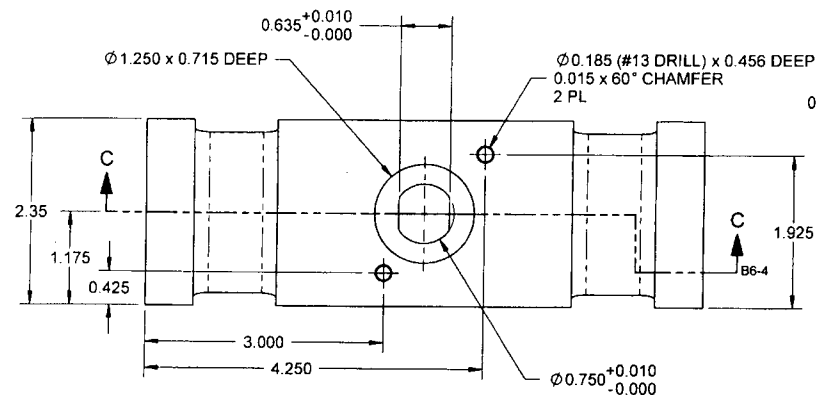
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

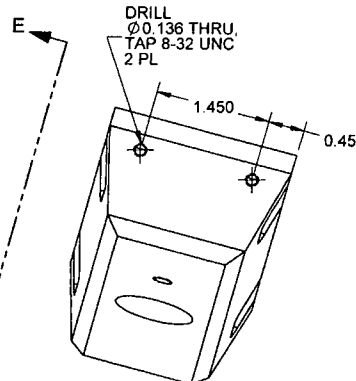
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



SECTION C-C D6-4



VIEW E-E

NOTES:

- 1) MATERIAL: 6061-T6/T651 PER QQ-A-200/8 OR QQ-A-225/8 OR ASTM B211 OR ASTM B221 REF. DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) MASK INSIDE HOLES PRIOR TO FINISH

D4571-3 COVER

RELEASED
R 2012-01-30

DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	MP	DRAWING NO. D4571	REV. B
MFG. APPR.		TITLE PEDAL LOCK	SHEET 4 OF 4
APPROVED		SCALE	NTS
DE APPR.	N/A	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	12.01.23		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

List Lots

Tuesday, April 10, 2012 12:38:16 PM

Page 1 of 1

Criteria : Item ID: d4571-3 All Locations All Warehouses All Quantity

Item ID Item Name	Warehouse ID Location ID	Lot Number	Last Trans Date	Lot Qty	Shelf Life Dt	Lot Code	Type Code	Comments
D4571-3 Cover	Main Warehouse GA	80805	3/29/2012	5.0000		QC21		
Total:				5.0000				

REFERENCE ONLY

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80805

February-29-12 11:44:21 AM

80805

Page 1

#62826

Item ID: D4571-3

Accept

N9000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Cover

Start Date: 29/02/2012 Start Qty: 5.00

5

Cust Item ID:

Required Date: 14/03/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan: MLCJ

Date: 12/02/29 Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4571	B

100	Cut blanks as per folio	0.00
-----	-------------------------	------

100

Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT TO 7.250" LONG

SL 12/03/13

5

105

105

HAAS I

Hardinge CNC LATHE SMALL

0.00

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOLIO FB081 AND DWG D4471

FOLIO REV: AA

DWG REV: B

DEBURR

PO/SL 12/03/22

5

REFERENCE

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D45713 PAR #: _____ Fault Category: Machining NCR: Yes No DQA: Start Date: 12/04/04
 Resolution: Acceptable Disposition: Acceptable QA: N/C Closed: ck Date: 12/4/4

NCR: <u>12-1302</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/03/21	105	hole tap too far from the edge Feed too high for center drill sing. The part is holding in the jaw with a small surface R. C. operator error	S 12/03/26 QS7042	Acceptable. test fits in no problem.	PD 21 12/03/21	S 12/03/26	S 12/03/26 QS7042	S 12/03/26

NOTE: Date & initial all entries

Work Order ID 80805

February-29-12 11:44:21 AM

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Page 2

Item ID: D4571-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Cover

Stop

NS2

Start Date: 29/02/2012 Start Qty: 5.00

5

Cust Item ID:

Required Date: 14/03/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 *110* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00	PD / SL 12-03-22			5			
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				5			
130 *130* HandFinish Hand Finishing	Chemical Conversion Coat per QS1005 4.1 Memo	0.00 0.00	ml 12/03/22						
						6			BL 123-27.

Work Order ID 80805

February-29-12 11:44:21 AM

80805

Page 3

Item ID: D4571-3

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Cover

Stop

NS2

Start Date: 29/02/2012 Start Qty: 5.00

5

Cust Item ID:

Required Date: 14/03/2012 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Fire Red(Ref:4.3.5.10) per QSI005 4.3	0.00							
140									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <u>7h30</u> FINISH TIME: <u>9h00</u> OVEN TEMPERATURE: <u>320°C</u>								
				M113645					
145 QC3									
150	Identify as per dwg & Stock Location <u>GA</u>	0.00							
150									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.00							
Quality Control									

6 2 (2P) 12/03/29.

Pto →

Sp 12/03/29

(6)

12/3/29

12/03/29

Dart Aerospace Ltd

W/O: 80805		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
		Perm. change						
12/03/29	# 145	ADD step for QC3.	BL TS	12-3-29 12-03-29	5.		S 12-3/29	
	# 145	QC3 computer	H E	12-3-29 12-03-29			S 12/03/29	

Part No: D4571-3 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February-29-12 11:44:25 AM

Page 1

Work Order ID: 80805

80805

Parent Item: D4571-3

D4571-3

Parent Item Name: Cover

Start Date: 29/02/2012

Required Date: 14/03/2012

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP REV:A NEW ISSUE 11-12-21 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X02.50 0		Purchased	No				f	78.2500		3.210526			

M6061T6B1 500X02 500

**

6061-T6 Bar 1.50 x 2.50

12/03/13

Location

Loc Qty

Loc Code

MAT004

78.25

103069

12

107387

30.25

16742

36

3.3

DART AEROSPACE LTD	Work Order: 80805
Description: COVER	Part Number: 04571-3
Inspection Dwg: 04571-3 Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0,635	+0,010 -0,000	0,635	✓		VERN	GA-09
Ø 1,250	±0,010	1,250	✓		"	"
0,715	±0,010	0,715	✓		"	GA-09
2,350	±0,030	2,350	✓		VERN	GA-09
1,175	±0,010	1,175	✓		"	"
0,425	±0,010	0,423	✓		"	"
3,000	±0,010	3,003	✓		"	"
4,250	±0,010	4,250	✓		"	"
Ø 0,750	±0,010 -0,000	0,750	✓		"	"
1,925	±0,010	1,923	✓		"	"
Ø 0,185x0,456	±0,010	0,186x0,456	✓		"	"
7,000	±0,030	7,003	✓		height G	"
5,800	±0,010	5,798	✓		VERN	GA-09
3,700	±0,010	3,700	✓		"	"
1,050	±0,010	1,049	✓		"	"
0,850	±0,010	0,850	✓		"	GA-08
1,200	±0,010	1,195	✓		"	GA-08 GA-09
3,500	±0,010	3,500	✓		"	GA-09
1,850	±0,010	1,850	✓		"	GA-09
Ø 1,00	±0,010 -0,001	0,999	✓		"	"
2,00	±0,030	2,001	✓		height G	
0,443	±0,010	0,441	✓		VERN	GA-09

Measured by: PD / J
Date: 12/03/21

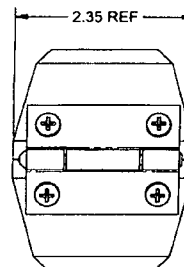
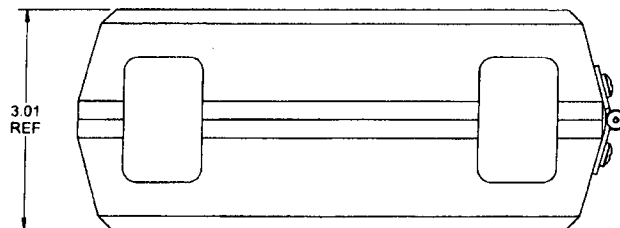
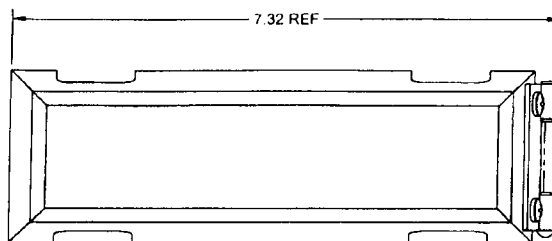
Audited by: <i>mk</i>
Date: 12/03/22

Preliminary Approval:
Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

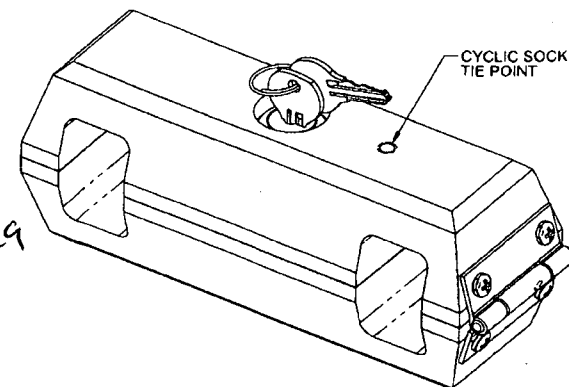
10.04.15

ITEM	QTY -041	QTY -051	P/N	DESCRIPTION
	X		D4571-041	TAIL ROTOR DISABLING KIT
	1	X	D4571-051	PEDAL LOCK
	1		D3384-047	CYCLIC SOCK
	1		MS 18995-47	SCREW, SKT-HD
	2		AN960-416	WASHER, FLAT
1		1	D3373-5	CAM LOCK ASSEMBLY
2		1	D3385-3	HINGE
3		1	D4571-1	BASE
4		1	D4571-3	COVER
5		4	MS51957-41	PH-HD SCREW, #8
6		2	97395A461	DOWEL PIN (MCMaster CARR)



D4571-051 PEDAL LOCK

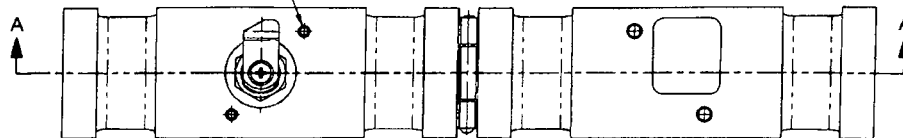
80805.MLJ
12/02/29



RELEASED
2012-01-30

B	ADDED CYCLIC SOCK AND RELATED HARDWARE TO BOM ADDED DIM 0.560, DELETED DIM 0.188 SHT 3 ADDED DIM 1.200, DELETED DIM 0.300 SHT 4	RP	12.01.23
A	NEW ISSUE	RP	12.01.06
REV.	DESCRIPTION	BY	DATE
DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	MP	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4571	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	N/A	PEDAL LOCK	NTS
DATE	12.01.23	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

97395A461
DOWEL PIN (MCMASTER CARR)



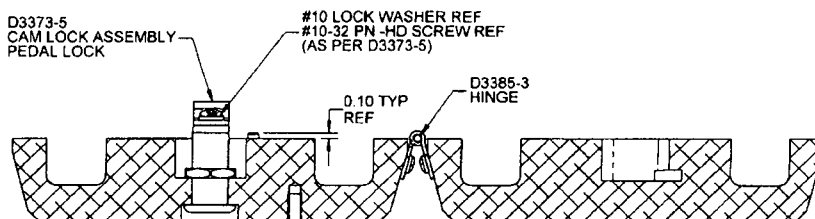
D4571-3
COVER

D4571-1
BASE

D4571-051 PEDAL LOCK ASSEMBLY

D3373-5
CAM LOCK ASSEMBLY
PEDAL LOCK

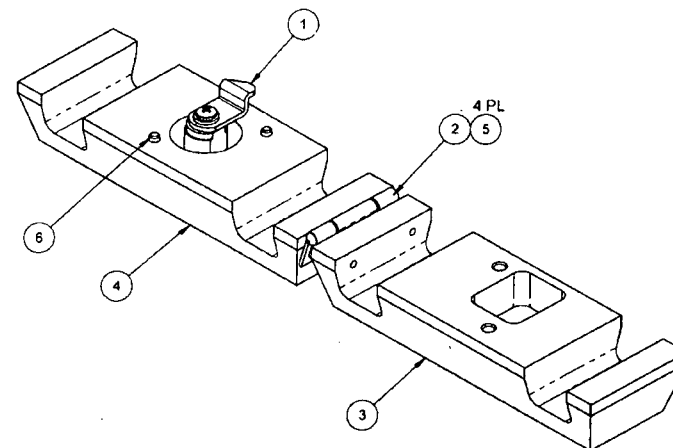
#10 LOCK WASHER REF
#10-32 PN -HD SCREW REF
(AS PER D3373-5)



0.10 TYP
REF

D3385-3
HINGE

SECTION A-A

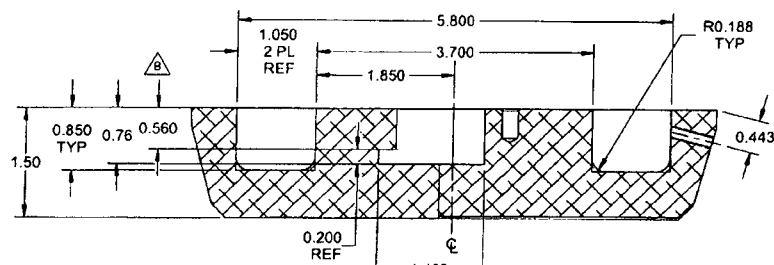
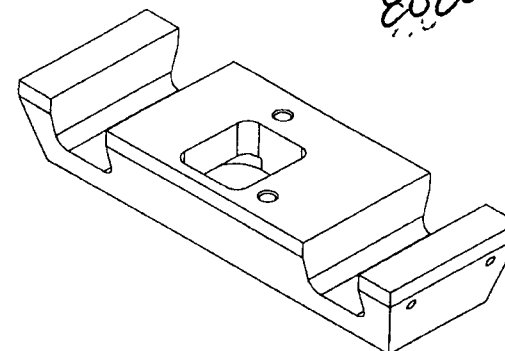
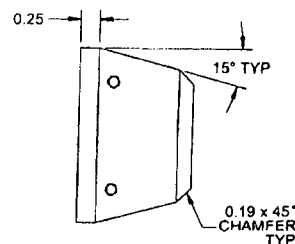
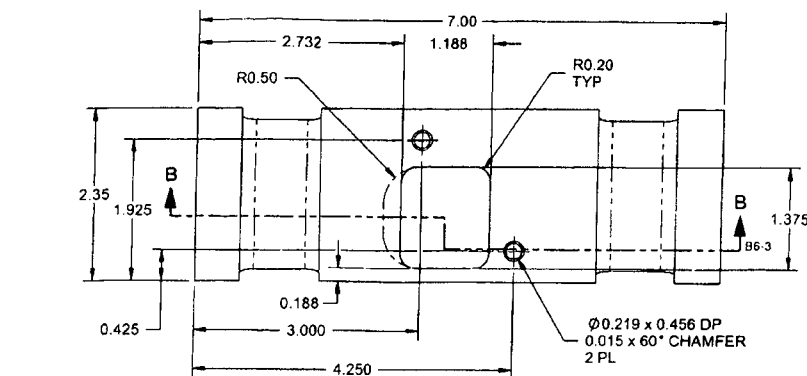


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2012-01-30

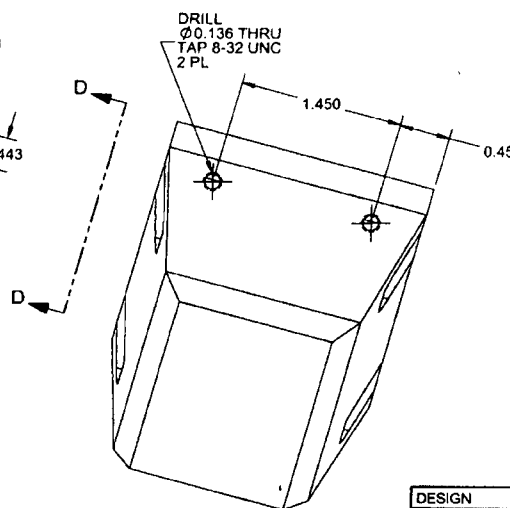
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.75 lbs

DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	MP	DRAWING NO. D4571	REV. B
MFG. APPR.	<i>[Signature]</i>	TITLE	SCALE
APPROVED	<i>[Signature]</i>	PEDAL LOCK	NTS
DE APPR.	N/A	COPYRIGHT © 2012 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR FOR ANY COMMUNICATIONS TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	12.01.23		



SECTION B-B C6-3



VIEW D-D

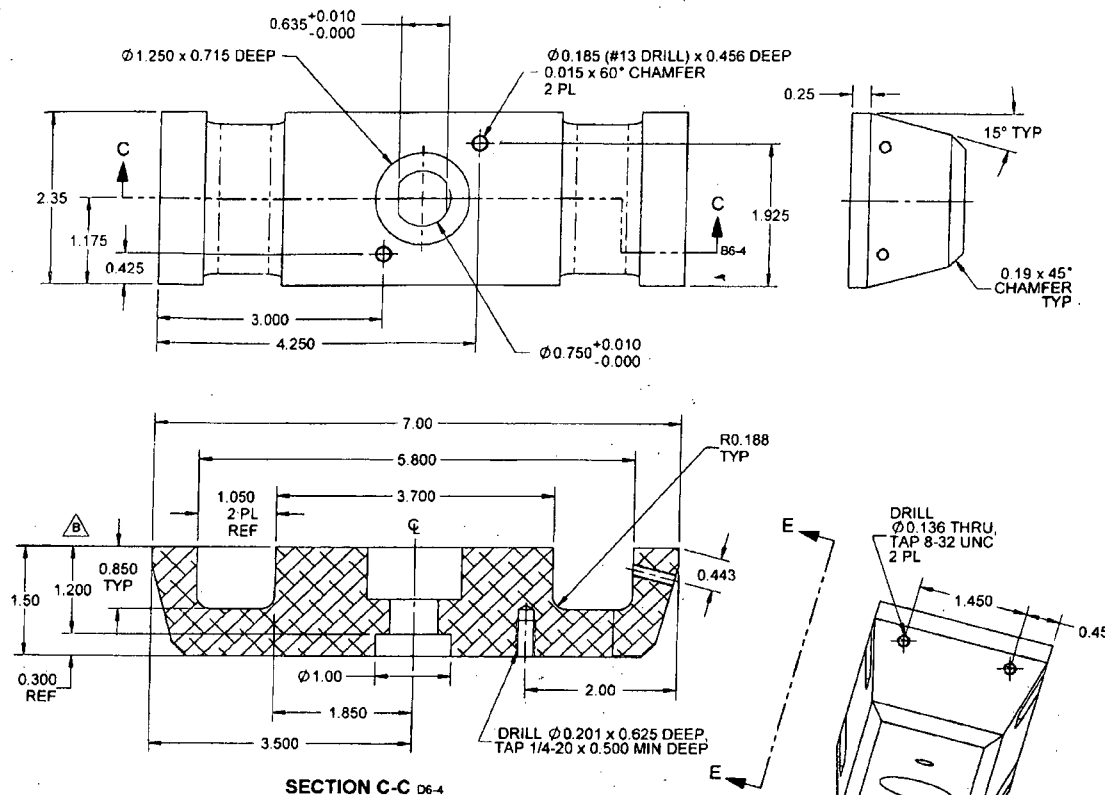
NOTES:

- 1) MATERIAL: 6061-T6/T651 PER QQ-A-200/8 OR QQ-A-225/8 OR ASTM B211 OR ASTM B221
REF. DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) MASK INSIDE HOLES PRIOR TO FINISH

D4571-1 BASE

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2012-01-30

DESIGN	RP	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MP	DRAWING NO.	REV. B
MFG. APPR.	B	D4571	SHEET 3 OF 4
APPROVED	IND	TITLE	SCALE
DE APPR.	N/A	PEDAL LOCK	NTS
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NOTES:

- 1) MATERIAL: 6061-T6/T651 PER QQ-A-200/8 OR QQ-A-225/8 OR ASTM B211 OR ASTM B221 REF. DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) MASK INSIDE HOLES PRIOR TO FINISH

D4571-3 COVER

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2012-01-30

DESIGN	RP	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MP	DRAWING NO.	REV. B
MFG. APPR.		D4571	SHEET 4 OF 4
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